

Date: Monday, 10/11/2008 10:45:58 AM
User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: BASKET BASE ASSEMBLY (350)		
Job Number	: 43279C			Part Number	: D2221		
Estimate Number	: 10189			Drawing Number	: D2221 REVG		
P.O. Number	:			Project Number	: N/A		
This Issue	: 10/11/2008	S.O. No.	:	Drawing Revision	: G		
Prsht Rev.	: NC			Material	:		
First Issue	: / /	Type	: LARGE FAB ASSY	Due Date	: 28/11/2008		
Previous Run	: 43142A			Qty:	1	Um:	Each
Written By	:						
Checked & Approved By	: <u>JUL 08-11-10</u>						
Comment	: Est Rev:J 05.09.02 Added D3442-1 KJ/JLM Est Rev:K 08-08-29 revG as per dwg DD verified by:EC Est Rev:L 08-09-24 plug holes prior to powder coat DD verified by:EC						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D31661	Basket Hoop	
		Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s) Pick: Qty Part Number Description Batch <u>B91448(1)</u> 4 D3166-1 RIB <u>B42716(2) B3761(1)</u> SAD 08-11-20	
2.0	D22323	Basket Hinge	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Pick: Qty Part Number Description Batch <u>2 D2232-3 Hinge bracket B40895</u> ✓ <u>B39334</u> 18/08/11/24	
3.0	D2325	Support Gusset (350 Basket)	
		Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s) Pick: Qty Part Number Description Batch <u>4 D2325 Support Gusset B39913</u> ✓ <u>18/08/11/24</u>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action		Section B	Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng				

NOTE: Date & initial all entries

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Seq. #: Machine Or Operation:

Description :

4.0 D23273

Spacer Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch
2 D2327-3 Bushing B39560

SL 08/11/21

5.0 D2581

Mounting Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch
2 D2581 Mounting Bracket B40895

SL 08/11/24

6.0 D34421

Shim



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch
2 D3442-1 Shim B40392

SL 08/11/24

7.0 M304EX07516F

Expanded Metal Flat SS



Comment: Qty.: 41.6745 sf(s)/Unit Total : 41.6745 sf(s)

Pick:

Qty Part Number Description Batch
39.69 sf M304EX0.75-16F Expanded Metal M109383

SL 08/12/10

8.0 M304TS0750W065

304 SQ Tube .75x.75x.065W



Comment: Qty.: 29.4000 f(s)/Unit Total : 29.4000 f(s)

Pick:

28' 3/4" x 3/4" x 0.065 wall 304/316 SStubing
Batch: M108846

SL 08/12/10

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Job Number:



Seq. #: Machine Or Operation:

Description :

9.0 LARGE FAB 1



LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2235-1 Rib from D3166-1 Rib As Per Dwg D2235

2-Drill hole in D2221-3 as per Dwg D2221

3-Deburr

4-Remove all markings on material before welding

5-Weld as per Dwg D2221 using Welding Table and corner JigDeburr as required

8/08/12/11

10.0 QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

P/C 08.12.11

P/C 08.12.11

11.0 QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

S 08.12.11

12.0 POWDER COATING

POWDER COATING



M 10 a 1 S 2

(ix)

Comment: POWDER COATING

1- Plug holes in D2581 prior to powder coating

2-Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

1ST COAT:

8 - 30

START TIME:

OF

OVEN TEMPERATURE:

400

FINISH TIME:

9 - 00

***** 2nd coat if necessary *****

2ND COAT:

9 - 15

START TIME:

OF

OVEN TEMPERATURE:

400

FINISH TIME:

9 - 45

M-L 08/12/12

W/O:		WORK ORDER CHANGES						
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Job Number:



Seq. #:	Machine Or Operation:	Description :
13.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION		<i>FZ 08/12/15</i>
14.0	QC21	FINAL INSPECTION/W/O RELEASE
Comment: FINAL INSPECTION/W/O RELEASE		<i>1 08/12/19</i>

Job Completion

*MF 68-12-19*

W/O:		WORK ORDER CHANGES						
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

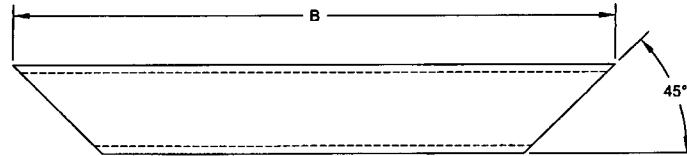
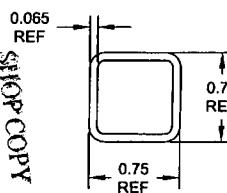
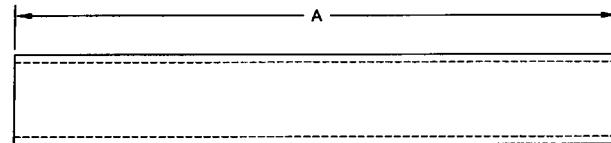
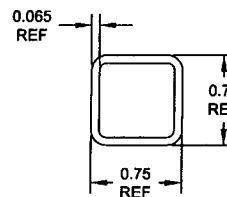
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DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

PARTS LIST FOR D2221 BASKET BASE ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D2221-1	2	—	96.00	RIB
D2221-3	2	—	25.50	RIB
D2221-5	2	18.88	—	RIB
D2221-7	1	55.25	—	RIB
D2232-3	2	N/A	N/A	HINGE PLATE
D2235-1	4	N/A	N/A	RIB
D2325	4	N/A	N/A	SUPPORT GUSSET
D2327-3	2	N/A	N/A	BUSHING
D2581	2	N/A	N/A	MOUNTING BRACKET
D3442-1	2	N/A	N/A	SHIM



RELEASED
06-06-21

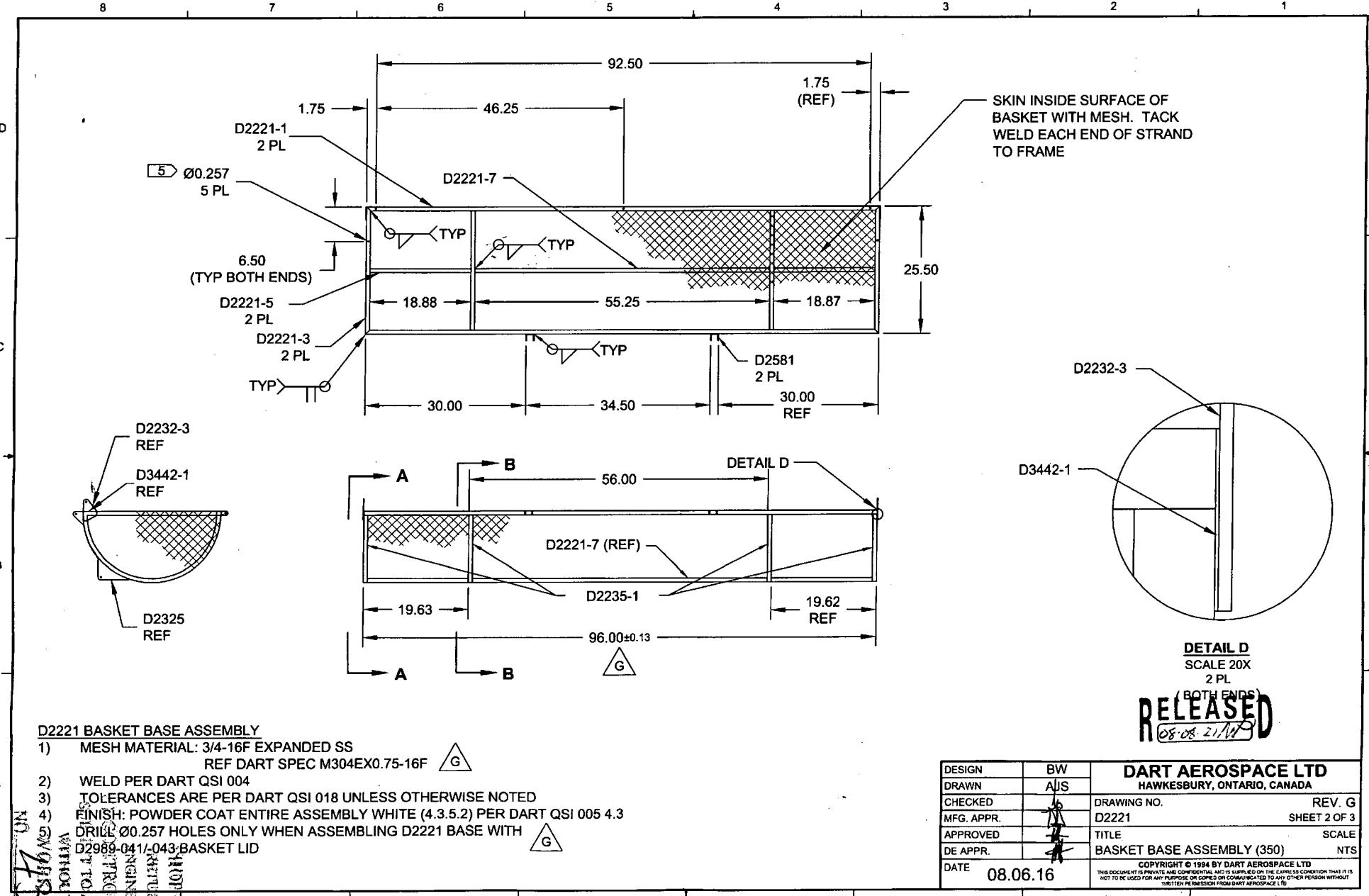
G	MATERIAL FOR -1, -3, -5, & -7 WAS 0.060 WALL. SHT 2 ZN B.5 TOLERANCE FOR 96.00 DIM WAS +/- .001, 56.00 DIM WAS REF. SHT 2 ZN B4 19.62 DIM WAS "HARD" DIMENSION IS NOW REF. NOTE 5 TRANSFERRED FROM SHT 1 TO SHT 2. SHT 2 MESH MATERIAL UPDATED. DRAWING TRANSFERRED TO "B" FORMAT.	AJS	08.06.16
F	ADD SHIM UNDER HINGES. ADD HOLES FOR SPLIT LID BASKETS	PH	05.06.07
E	CHANGE HINGE	CP	01.04.19
D	CHANGE LATCH	BW	96.06.21
C	SEPERATE BASKET AND LID	KH	95.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS	DRAWING NO. D2221 REV. G SHEET 1 OF 3	
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.06.16		

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D2221-1-3/-5/-7
 1) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
 2) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.065 WALL SQUARE TUBING
 REF. DART SPEC M304TS0.750W.065
 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) ALL DIMENSIONS ARE IN INCHES

G

8 7 6 5 4 3 2 1



D2221 BASKET BASE ASSEMBLY

1) MESH MATERIAL: 3/4-16F EXPANDED SS
REF DART SPEC M304EX0.75-16F 

2) WELD PER DART QSI 004

3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

4) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3

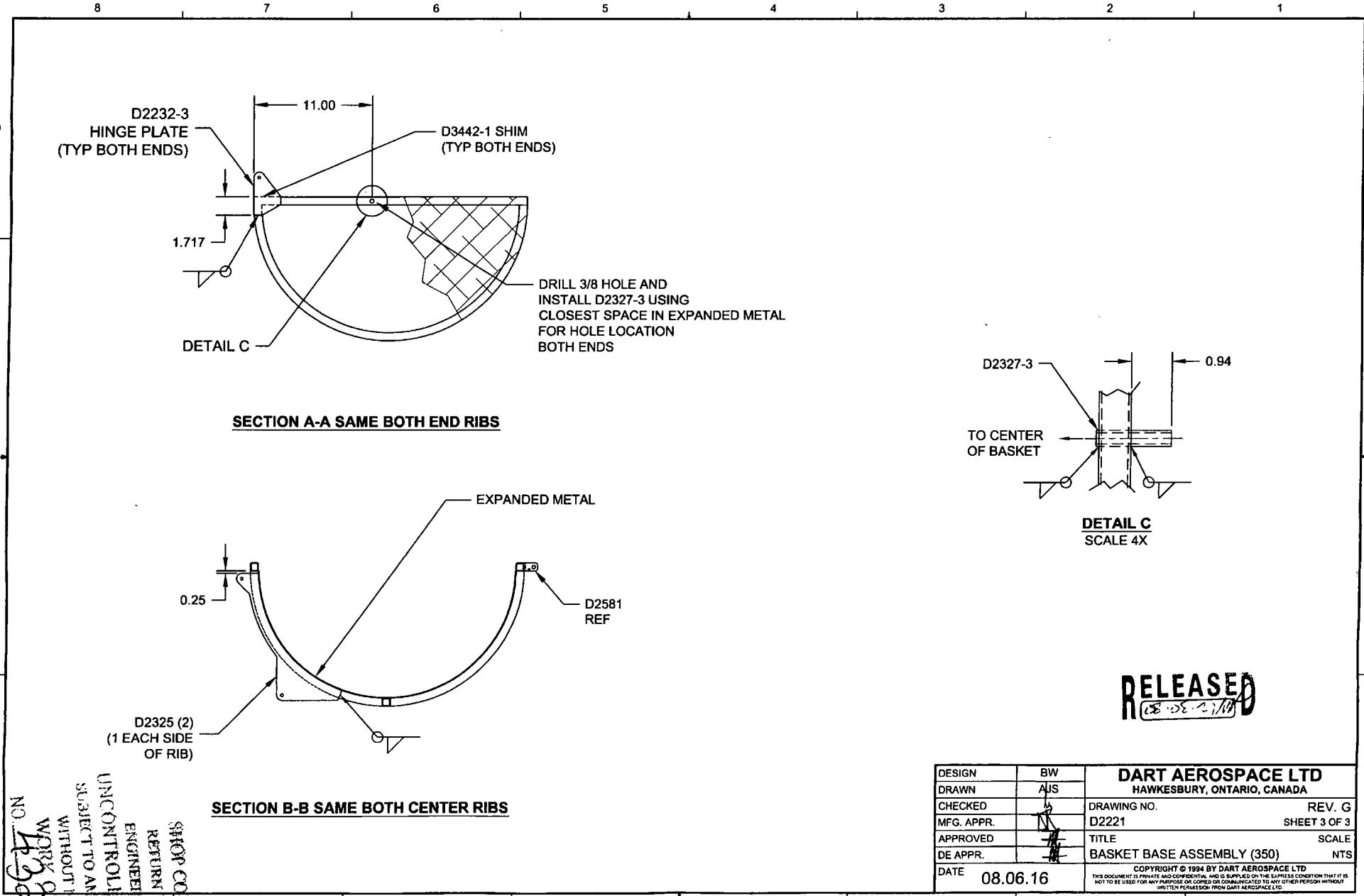
5) DRILL Ø.0257 HOLES ONLY WHEN ASSEMBLING D2221 BASE WITH D2989-041-043-BASKET LID 

4) ENGLISH: POWDER
DRILL 00.257 H
D2989-041-043
BY ENGINEERING
RECORDED COPY
NO. 4430A
WITH NOTICE
NO. 4430A

DESIGN	BW	DART AEROSPACE LTD	
DRAWN	AUS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[initials]</i>	DRAWING NO.	REV. G
MFG. APPR.	<i>[initials]</i>	D2221	SHEET 2 OF 3
APPROVED	<i>[initials]</i>	TITLE	SCALE
DE APPR.	<i>[initials]</i>	BASKET BASE ASSEMBLY (350)	
DATE	08.06.16	NTS	

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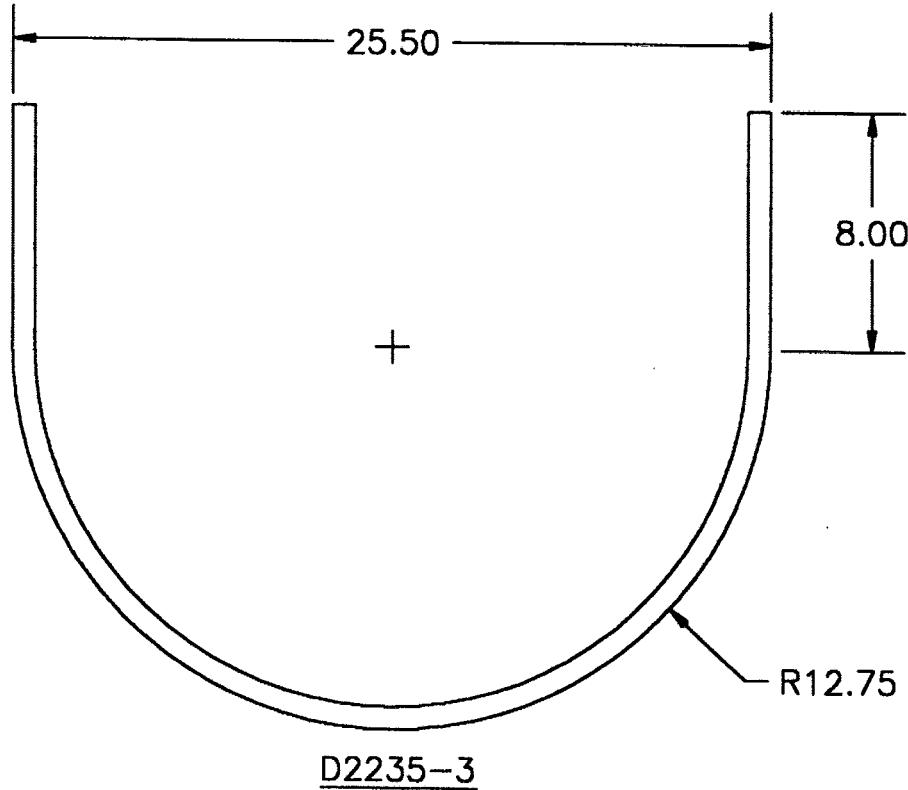
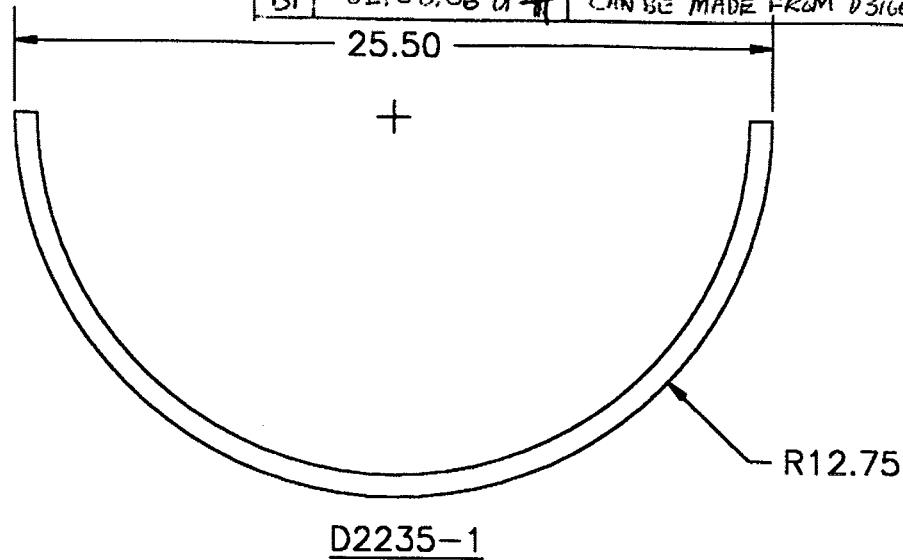
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DART

DESIGN B WILLIAMS	DRAWN BY B WILLIAMS	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>Su</i>	APPROVED <i>BW</i>	DRAWING NO. D2235	REV. B SHEET 1 OF 1
DATE 94:12:16		TITLE BASKET RIBS	SCALE
	BI 02.08.06 U/H	CAN BE MADE FROM D3166-1	

RELEASED
R 960507



CAN BE MADE FROM D3166-1 BI
MATERIAL: 304/316 SS, 3/4 X 3/4 X 0.063 WALL SQR.

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